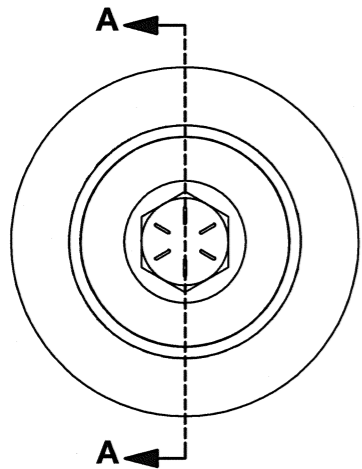
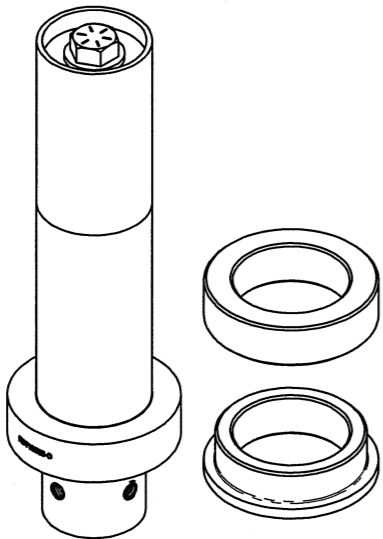
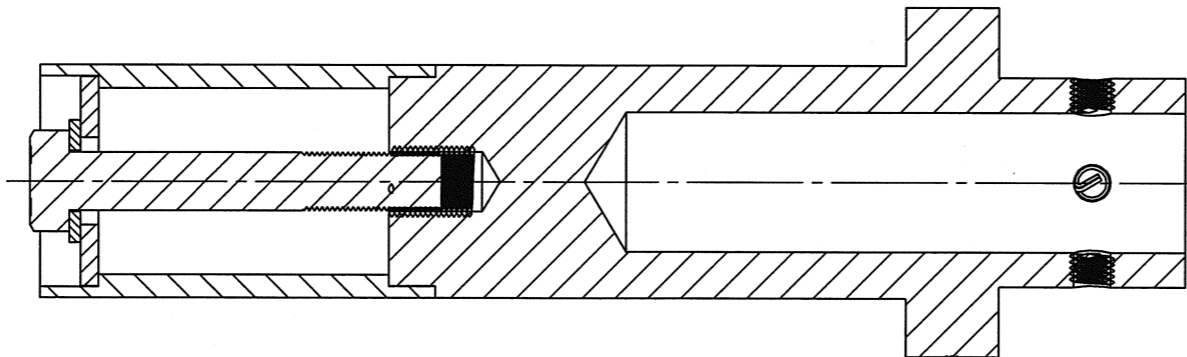


ITEM #	QTY	PART #	PART TITLE
-2	1	RBT18522-C-2	HUB ASSY
-3	1	RBT18522-C-3	TUBE WELDMENT
4	1	RBT18649-1-1	SLEEVE A
5	1	RBT18649-1-2	SLEEVE B
6	1	McMaster#91257A829 OR EQUIV	ZINC YELLOW PLATE STEEL GRADE 8 HEX HEAD SCREW 5/8"-18 X 4" LG.
7	1	McMaster#90126A035 OR EQUIV	ZINC PLATE STEEL FLAT WASHER FOR 5/8" SCREW SIZE 0.656" ID X 1.312" OD X 0.074"-0.121" THK



RBT18522-C 407 ADAPTER

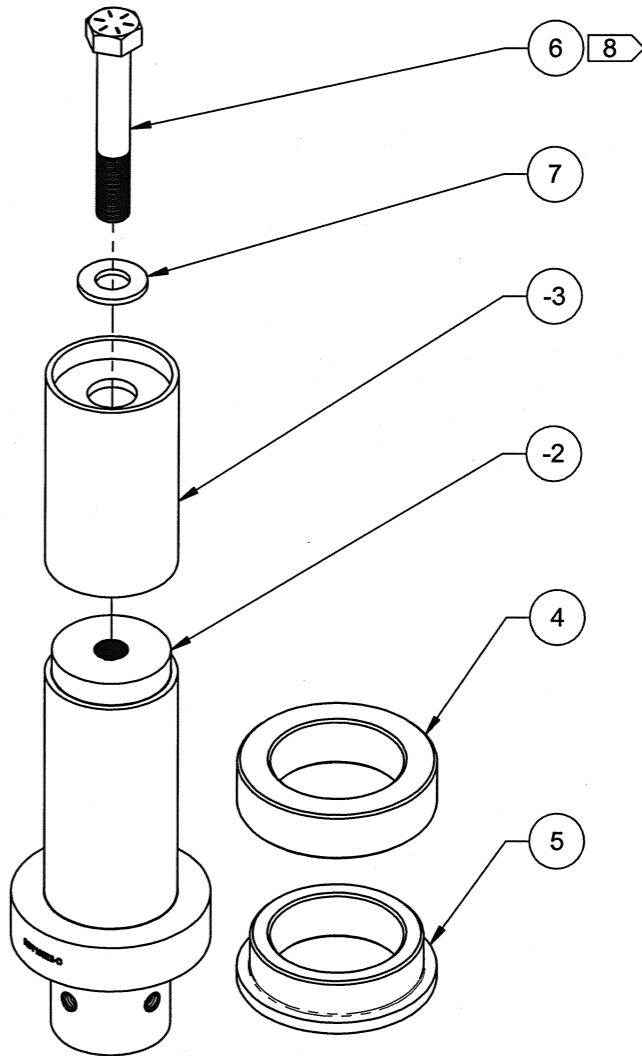
9



SECTION A-A

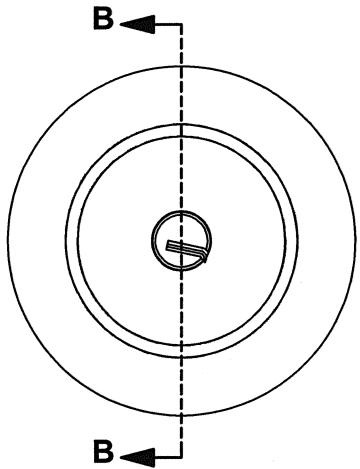
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH:
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 6 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

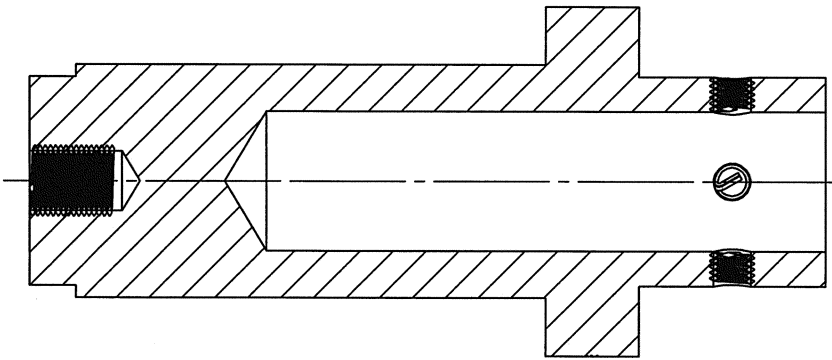


G	SEE PREVIOUS PDFs FOR OLD REVS TEMPLATE UPDATED PER DART HBY STANDARDS RBT18649-5 CHANGED FOR RBT18649-1-1 RBT18649-7 CHANGED FOR RBT18649-1-2 ITEM -9 McMaster#91247A444 CHANGED FOR ITEM 6 McMaster#91257A829 ITEM RBT18522-C-2 ASSY ADDED ITEM 8 AND ITEM 9 HELICOIL ADDED ITEM -1 MATERIAL 6061 CLEAR ANODIZE CHANGED FOR 6061/7075 RED ANODIZE, DIMENSION $\phi 1.5 \nabla 6.0$ CHANGED FOR $\phi 1.50 \nabla 6.00$, DIMENSION 4X 3/8-16 UNC -2B $\nabla .38$ E.Q.S CHANGED FOR TAP FOR 3/8-16 HELICOIL $\nabla 0.75$ 4PL, ENGRAVING S/N AND "MADE IN USA" REMOVED, DIMENSION .50 CHANGED FOR 0.500 +0/-0.005, DIMENSION $\phi 2.25 +0/-0.01$ CHANGED FOR 2.245 +0/-0.005, DIMENSION $\phi 2.240$ CHANGED FOR 2.240 +0.005/-0, DIMENSION R0.008 MAX 3PL ADDED, DIMENSION $\phi 2.50$ CHANGED FOR $\phi 2.500$, DIMENSION 5/8- 18 UNF -2B $\nabla 1.00$ CHANGED FOR TAP FOR 5/8-18 HELICOIL $\nabla 1.00$ ITEM -3 WELDING SYMBOL CHANGED, FINISH ZINC PLATE TYPE I CHANGED FOR YELLOW ZINC PLATE TYPE 2 ITEM -5 MATERIAL DOM CHANGED FOR A513 TYPE 5 DOM TUBING, DIMENSION .50 CHANGED FOR 0.500 +0.005/-0, DIMENSION $\phi 2.250$ CHANGED FOR $\phi 2.250 +0.005/-0$, DIMENSION $\phi 2.260$ CHANGED FOR $\phi 2.26 +0.01/-0$, DIMENSION $\phi 2.480$ CHANGED FOR $\phi 2.500$		19-758	VM
	REV.	DESCRIPTION	ECN #	BY
	DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VM		
	CHECKED	KPT	TOOL PART #	REV. G
	MFG. APPR.	JFC	RBT18522-C	SHEET 1 OF 5
	APPROVED	WLP	TITLE	SCALE
	DATE 2019-06-03		407 ADAPTER	NTS
			COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

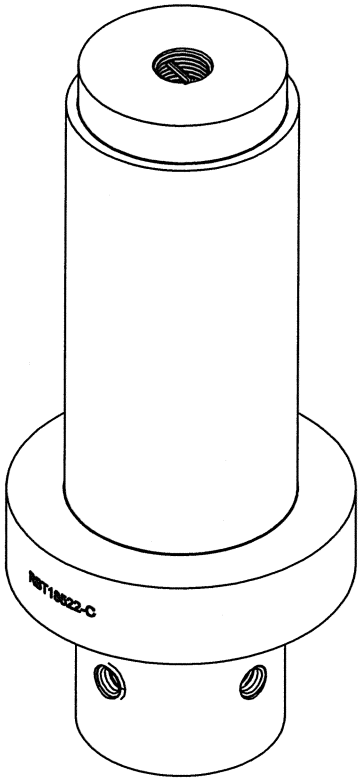
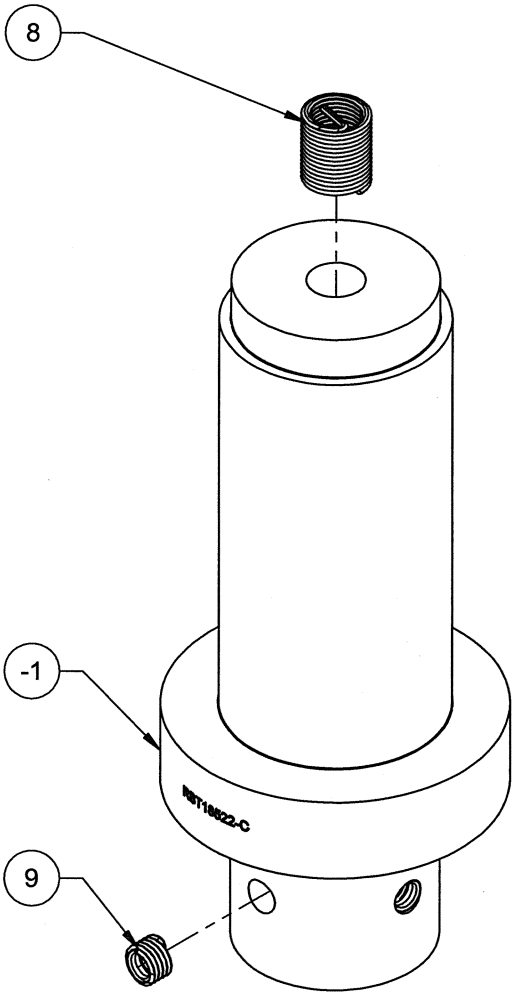
ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18522-C-1	HUB
8	1	McMaster#91732A238 OR EQUIV	SS18-8 HELICAL INSERT 5/8"-18 X 0.938" LG.
9	4	McMaster#91732A376 OR EQUIV	SS18-8 HELICAL INSERT 3/8"-16 X 3/8" LG.





RBT18522-C-2 HUB ASSY



SECTION B-B



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. G
MFG. APPR.	JFC	RBT18522-C	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DATE	2019-06-03	407 ADAPTER	NTS 
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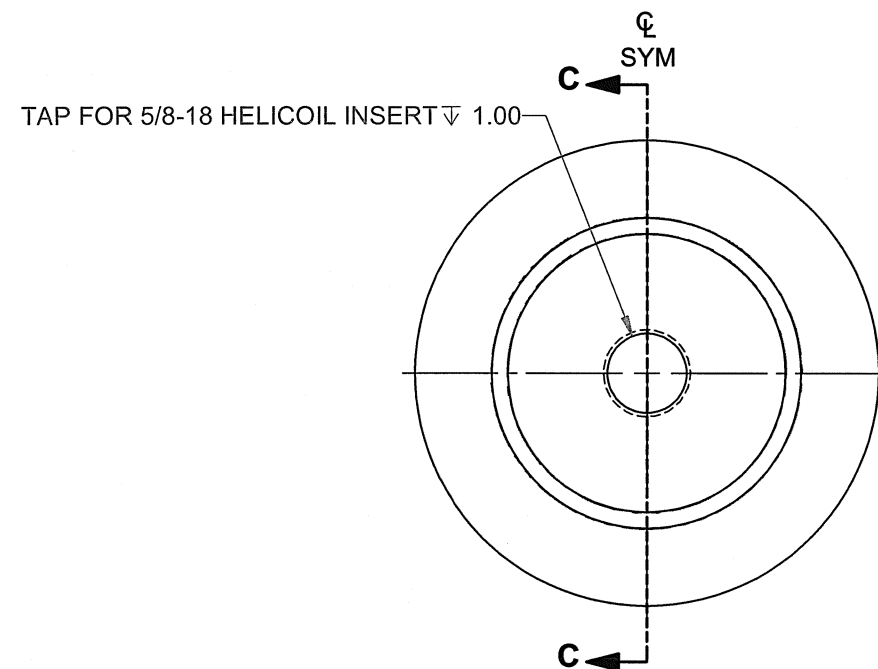
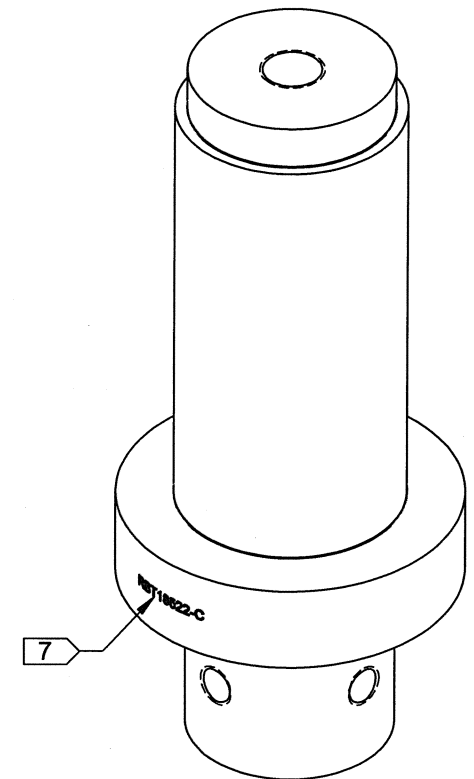
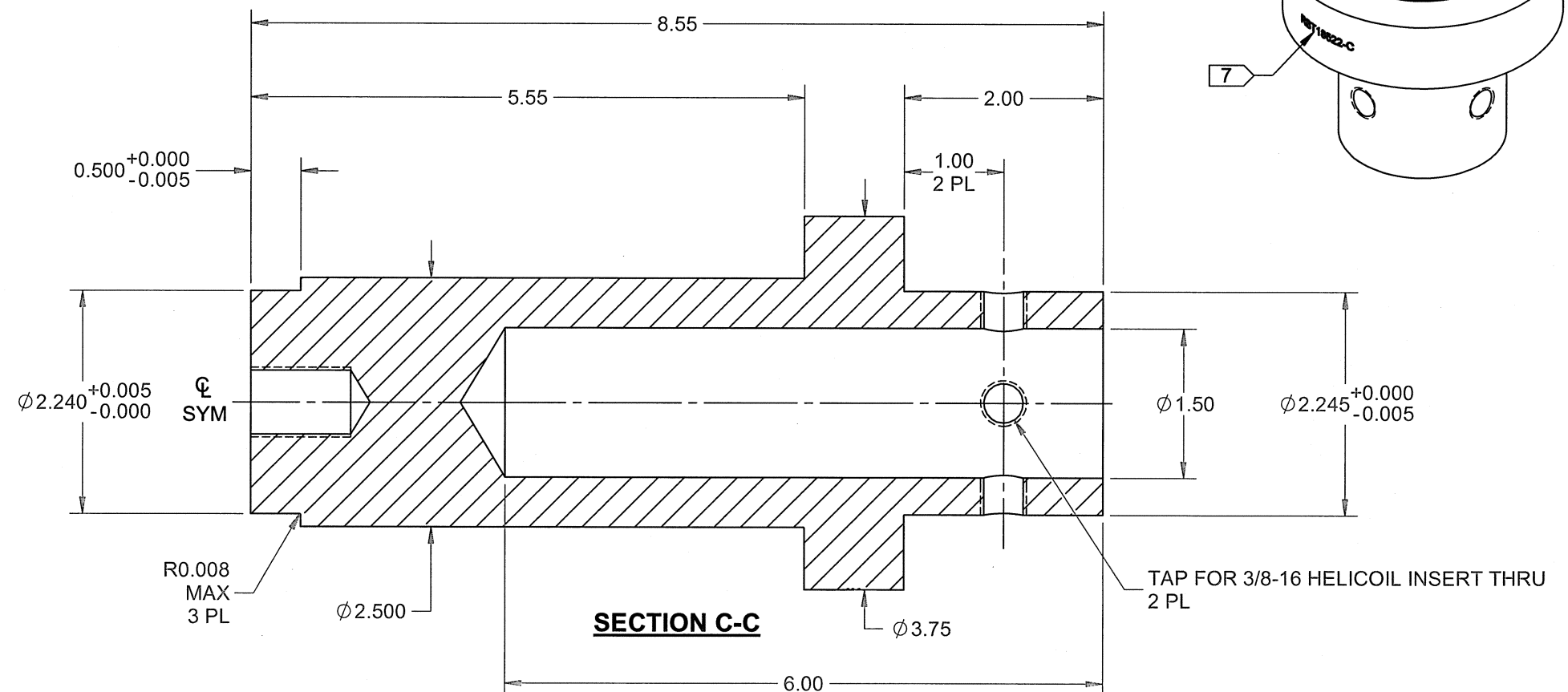
A

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C

B

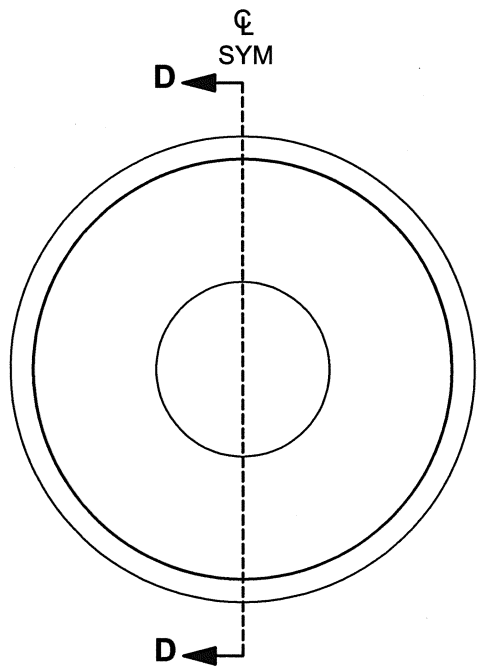
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**RBT18522-C-1 HUB****NOTES:**

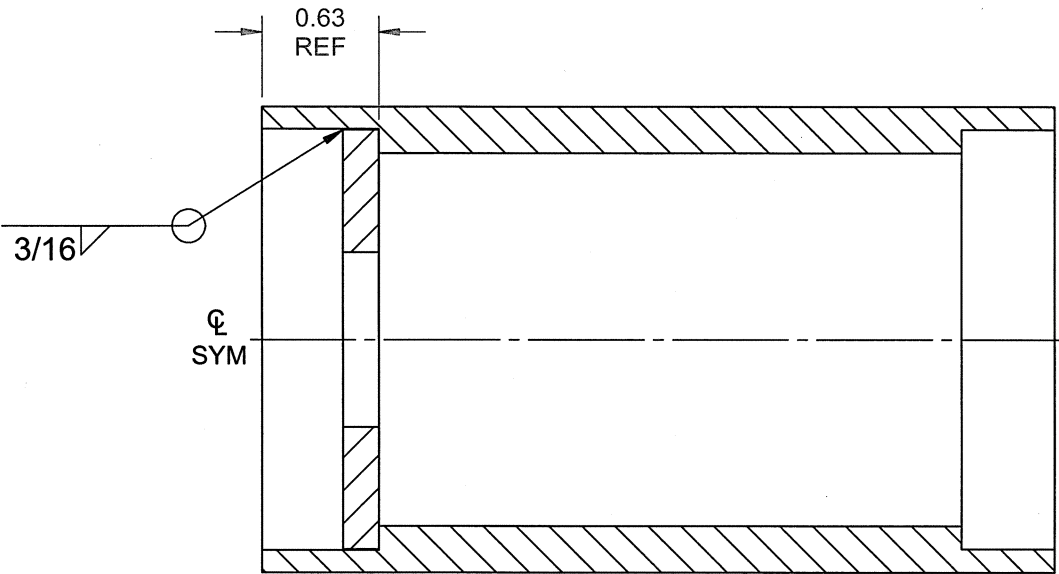
- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBT18522-C", AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. G
MFG. APPR.	JFC	RBT18522-C	SHEET 3 OF 5
APPROVED		TITLE	SCALE
		407 ADAPTER	NTS 
DATE	2019-06-03	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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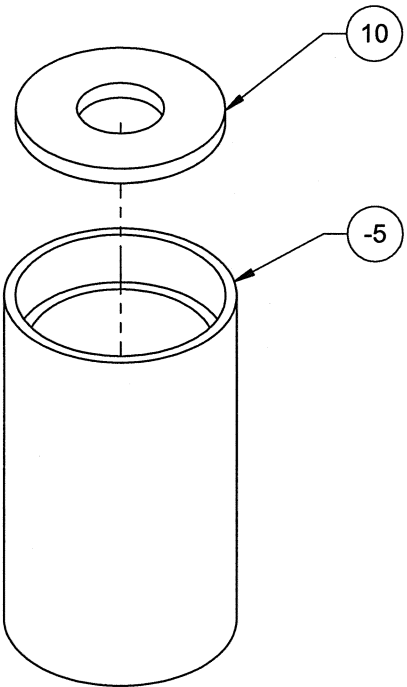
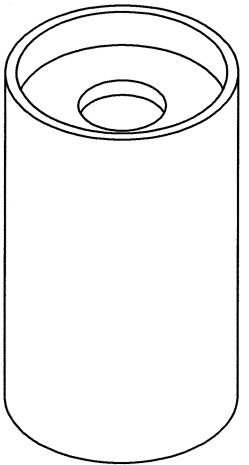
ITEM #	QTY	PART #	PART TITLE
-5	1	RBT18522-C-5	TUBE
10	1	McMaster#91081A037 OR EQUIV	STEEL USS FLAT WASHER FOR 7/8" SCREW SIZE 0.938" ID X 2.25" OD. X 0.136"-0.192" THK.



RBT18522-C-3 TUBE WELDMENT



SECTION D-D



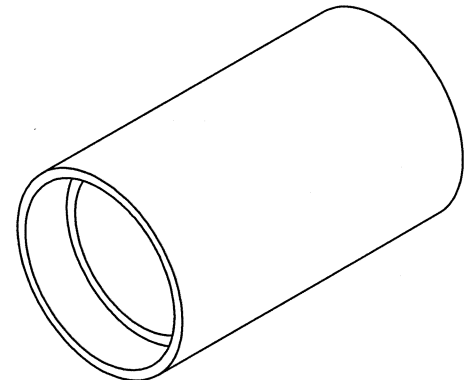
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. G
MFG. APPR.	JFC	RBT18522-C	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DATE	2019-06-03	407 ADAPTER	NTS
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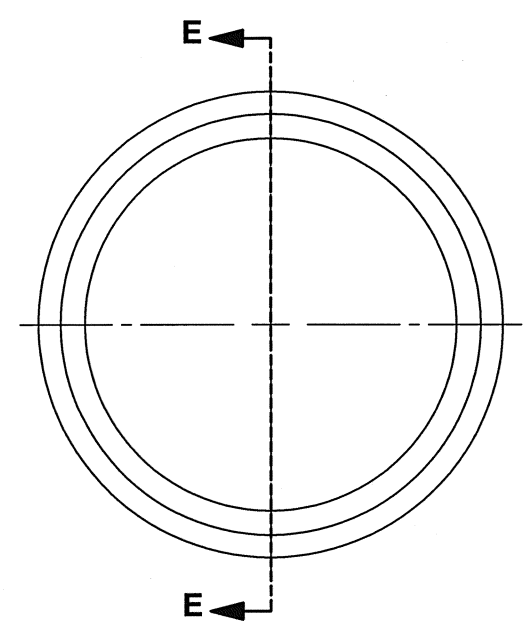
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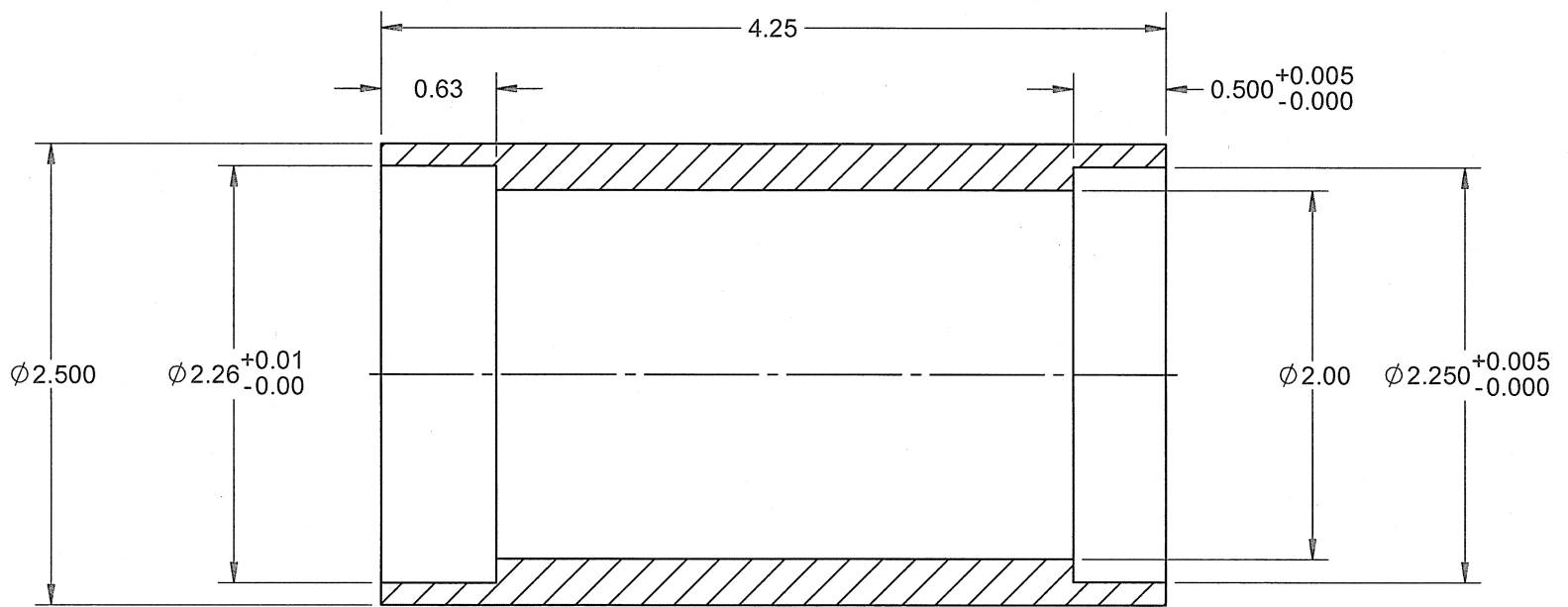


C

C



RBT18522-C-5 TUBE



SECTION E-E

B

B

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. G
MFG. APPR.	JFC	RBT18522-C	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DATE	2019-06-03	407 ADAPTER	NTS
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8 7 6 5 4 3 2 1